

split




Work Order ID 70532



Page 1


Friday, June 10, 2011 11:44:52 AM


Item ID: D3463-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Step Weldment Assembly
Start Date: 6/10/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 6/15/2011 Req'd Qty: 4.00 Customer:
Reference:


Approvals: Process Plan:  Date: 11-06-10 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------


Draw Nbr	Revision Nbr
D3463	Rev B

100		0.00
	Large Fab	
Large Fab	Memo	0.00
Large Fab	Weld assembly as per dwg D3463 using DT8875	

EL 11-7-6 

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
		
QC	Memo	0.00
Quality Control		

QC 11-07-06

120	QC5- Inspect part completeness to step on W/O	0.00
		
QC	Memo	0.00
Quality Control		

Subtotal

42

all

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70532

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Item ID:	D3463-04	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Weldment Assembly					
Start Date:	6/10/2011	Start Qty:	4.00			
Required Date:	6/15/2011	Req'd Qty:	4.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
	Memo 1- Mask areas indicated on dwg D3463 (holes, threads) START TIME: 12:00 OVEN TEMPERATURE: 400°F FINISH TIME: 12:30	0.00							2x ✓ M-Lub/07
140 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
	Memo	0.00							2x BK 11-7-7.
150 QC Quality Control	QC3- Inspect Part Finish	0.00							
	Memo	0.00							2 ✓ JH 6/10/07

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NOTE: Date & initial all entries

Work Order ID 70532

Friday, June 10, 2011 11:44:52 AM



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Item ID: D3463-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Identify as per dwg & Stock Location *G-A*

0.00



Packaging

Memo

w/o 70589



0.00

Packaging

w/o 70588



170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

EP 11/07/08

CK 11/07/08

ME

11-07-08

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 11:44:58 AM

Page 1

Work Order ID: 70532

Parent Item: D3463-041

Parent Item Name: Step Weldment Assembly



Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.18 new issue EC IPP revB: replace pressure
with wing walk DD 10.01.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806 SS DOWEL PIN 1" LONG		Purchased	No			100	Each	92.0000	2	8			
<div> <div>Location</div> <div>ST</div> <div>Loc Qty</div> <div>92</div> <div>Loc Code</div> </div>													
<div> <div>Location</div> <div>117606</div> <div>Loc Qty</div> <div>92</div> <div>Loc Code</div> </div>													
D3453-3 Clevis		Manufactured	No			100	Each	0.0000	1	4			
<div> <div>Location</div> <div>70854x4</div> <div>Loc Qty</div> <div></div> <div>Loc Code</div> </div>													
D3453-5 Plug		Manufactured	No			100	Each	15.0000	1	4			
<div> <div>Location</div> <div>WA023</div> <div>Loc Qty</div> <div>15</div> <div>Loc Code</div> </div>													
<div> <div>Location</div> <div>59204</div> <div>Loc Qty</div> <div>15</div> <div>Loc Code</div> </div>													
D3463-1 Arm		Manufactured	No			100	Each	0.0000	1	4			
<div> <div>Location</div> <div>69948x4</div> <div>Loc Qty</div> <div></div> <div>Loc Code</div> </div>													
D3463-3 Step		Manufactured	No			100	Each	26.0000	1	4			
<div> <div>Location</div> <div>WA025</div> <div>Loc Qty</div> <div>26</div> <div>Loc Code</div> </div>													
<div> <div>Location</div> <div>46269</div> <div>Loc Qty</div> <div>26</div> <div>Loc Code</div> </div>													

EL 11-7-4.

8

EL 11-7-4.

EL 11-7-4.

4

EL 11-7-4

EL 11-7-6

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 11:44:58 AM

Page 2

Work Order ID: 70532

Parent Item: D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 4.00

Required Qty: 4.00

D3463-5

Manufactured No

100 Each

13.0000 2 8



End Cap



EL 11-7-6

Location

Loc Qty

Loc Code

WA004

13

58928

13

D3463-7

Manufactured No

100 Each

3.0000 1 4



Drag Arm



EL 11-7-6

Location

Loc Qty

Loc Code

WA025

3

59199

1

62813

2

Friday, June 10, 2011 11:44:59 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

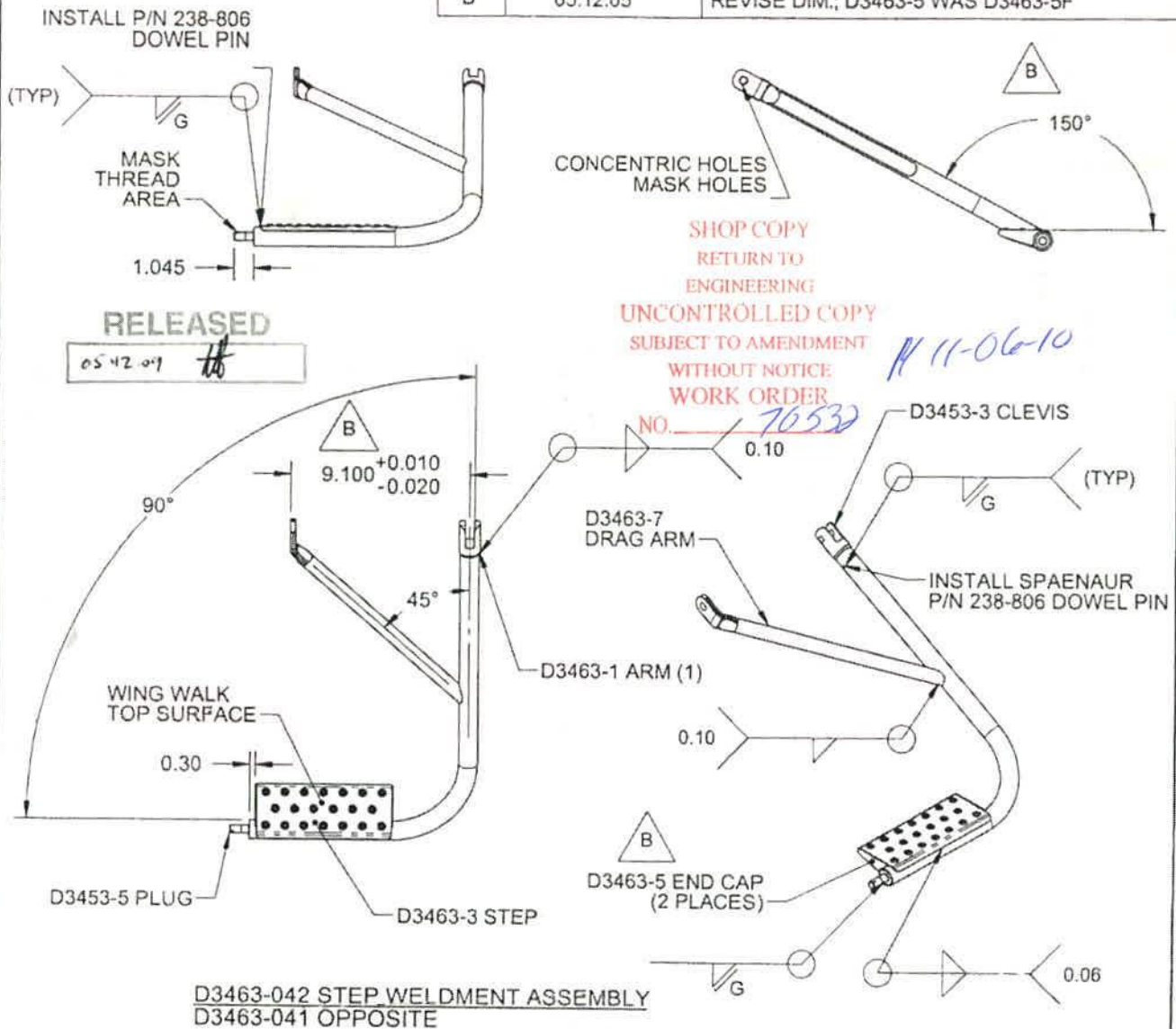
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

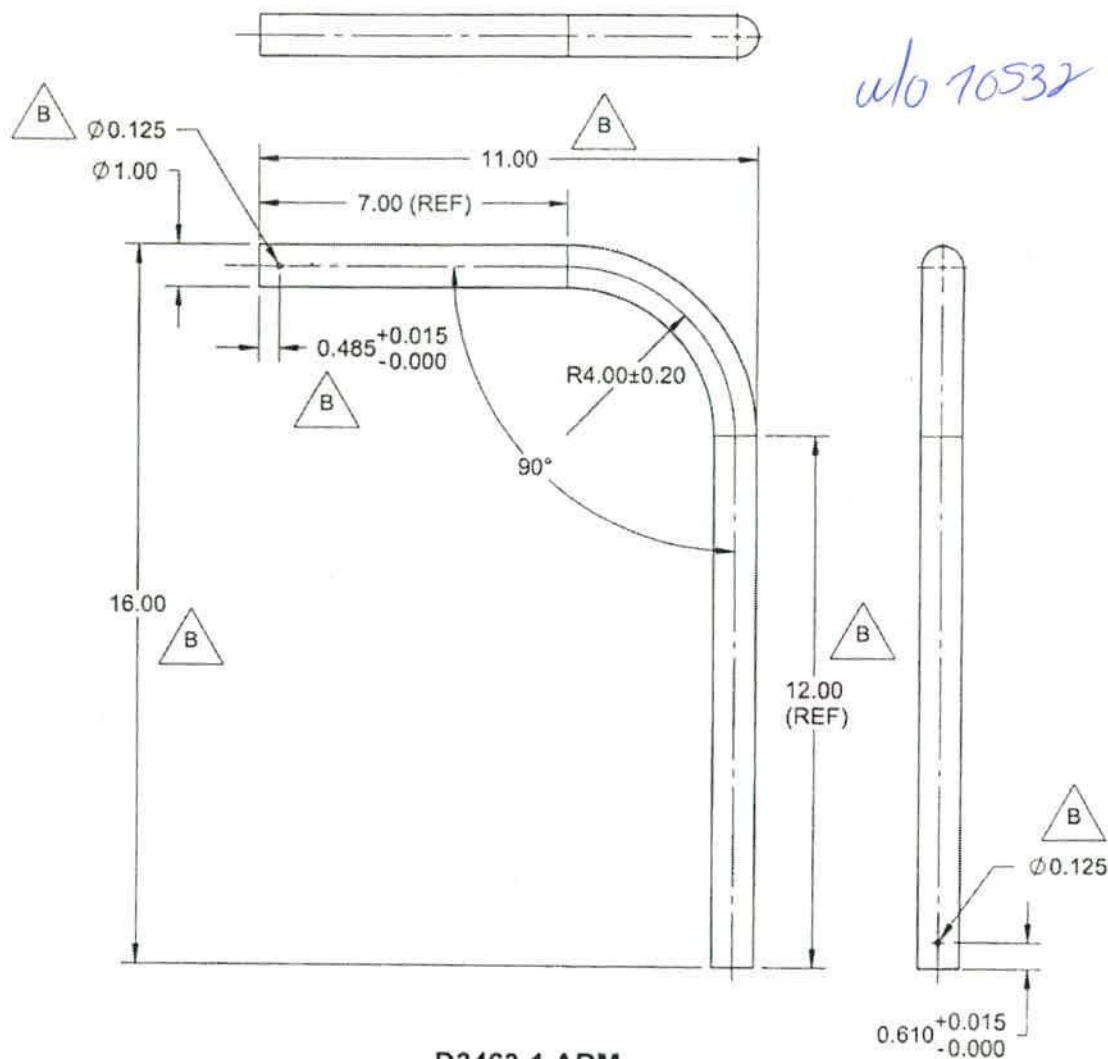
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05 *[Signature]***D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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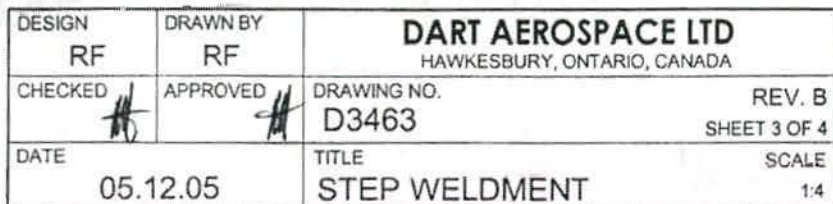
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



05.12.24 ~~11/11~~



1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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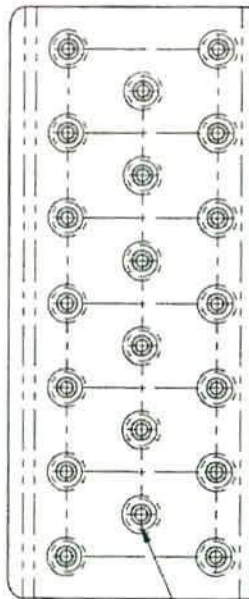
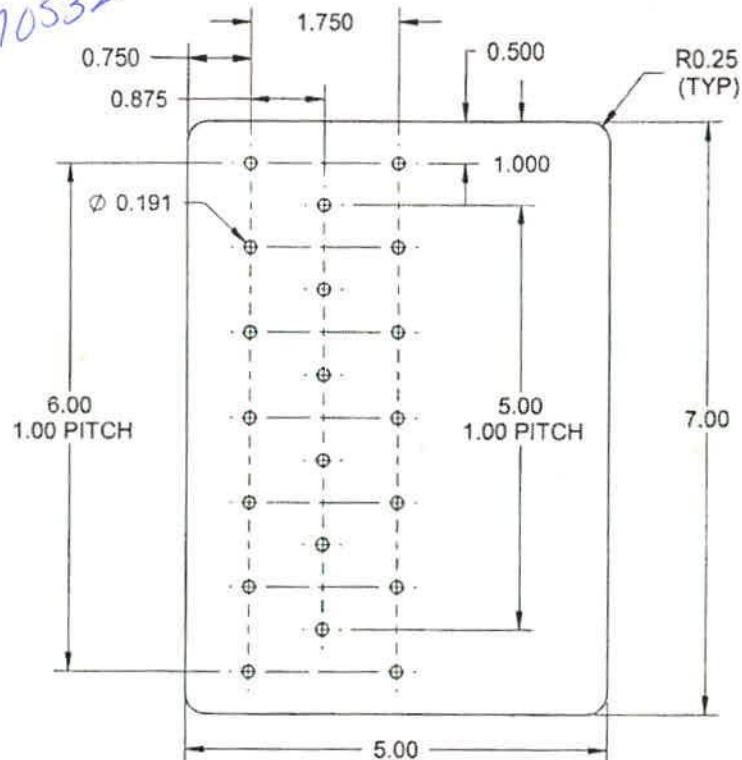
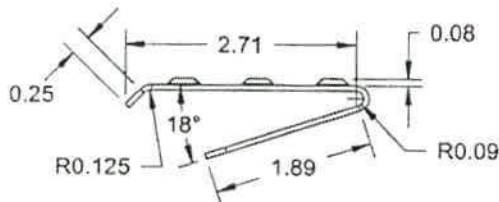
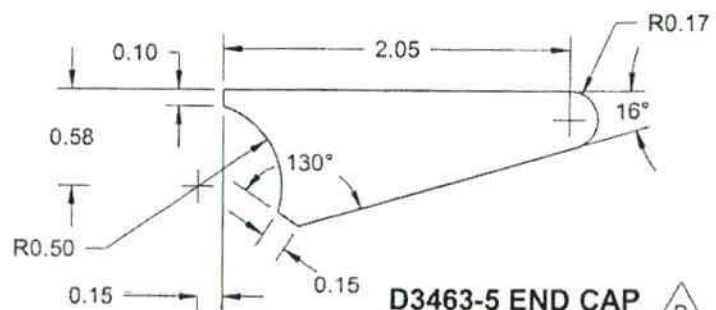
DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

05.12.05 #

w/070532

FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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